

Work Order ID 52407

September 23, 2009 11:44:49 AM

Page 1

Item ID: D350-602-011

Accept

Setup Start

Revision ID: N/A

Stop

Item Name: Heli-Utility-Pod (LH/RH)

Start Date: 9/23/09 Start Qty: 1.00

Cust Item ID:

Required Date: 9/30/09 Req'd Qty: 1.00

Customer:

Reference: REWORK

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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N/A	Rev N/A
-----	---------

100

0.00

DC

Memo

0.00

Document Control

Photocopy bluefile & type labels per PPP D350-602-011 CHG005

110

Pick Kit

0.00

Packaging

Memo

0.00

Packaging

PULL FROM STOCK
1 X D350-602-011 B

17429

090924

150

0.00

Small Fab

Memo

0.00

Small Fab

REWORK HINGE AREA PER DRWG
D2694

Hardener 9816 M112760 1 oz
EPOCAST 50A M112760 8 oz

add material, crack around hole
of Hinge, Taper flange opposite
QSI 37/6 side approx. 3/8 in.

AD62 ABS 090924
AD62 ABS M109582 38
902 clth M110804 38
M111166

2 sq ft

Primer filler gray
 Activator reducer
 Itron white
 Activator
 RTV sealant

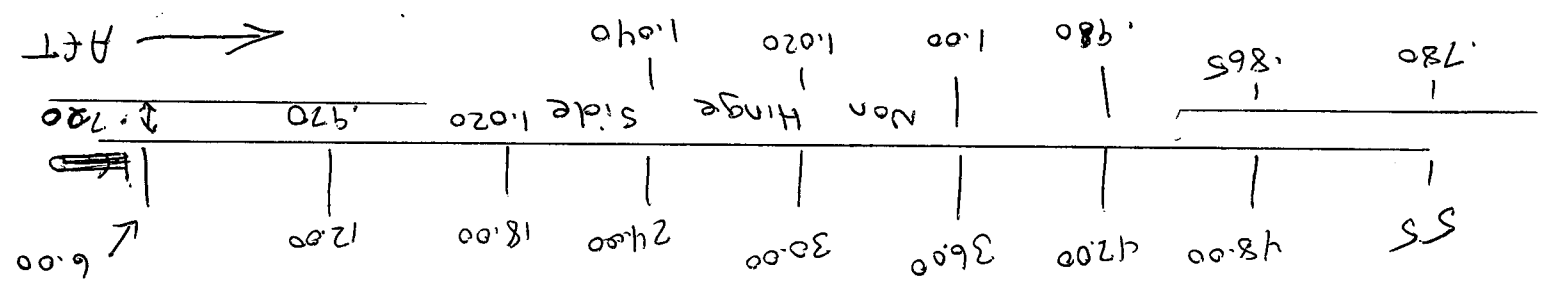
77045
 77755
 5554
 V1925
 732

M112 704
 M112 704
 M112 384
 M112 384
 M112 587

1qt
 1qt
 1qt
 1qt
 10ml

09/10/21

09/10/22



- Removed primer, Sanded back existing cloth, Added 4 layers
 of fiberglass cloth, Sanded smooth, Primer, Paint as req'd IAW
 Q5137


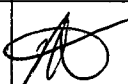
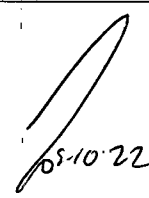
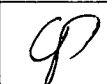
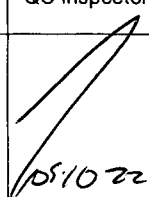
- Last hole Hinge side cracked to edge

- Sanded away primer and paint taper existing cloth IAW Q5137
 Replaced with 9oz cloth and Epocast 50A and Hardener 9816

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D350-602-011 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR: 52401		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
09.09.22	150	Width of pad varies, narrows in center, was does not have enough overlap, CRACK IN ONE HINGE RIVE HOLE	 09.10.22 per QSI 042	9oz cloth (4 layers) used to straighten edge of pad. (see previous page). Cracked hole repaired IAW QSI 037	 09/10/22	 09.10.22	 09.10.22 per QSI 042	 09/10/22

NOTE: Date & initial all entries

Work Order ID 52407

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Page 2

Item ID: D350-602-011

Accept

Setup Start

Revision ID: N/A

Stop

Item Name: Heli-Utility-Pod (LH/RH)

Start Date: 9/23/09 Start Qty: 1.00

Cust Item ID:

Required Date: 9/30/09 Req'd Qty: 1.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC5- Inspect part completeness to step on W/O

0.00

QC

Memo

0.00

Quality Control

170

QC3- Inspect Part Finish

0.00

QC

Memo

0.00

Quality Control

ENSURE ORIGINAL K10002 KIT IS REPACKAGED WITH POD

180

Identify as per dwg & Stock Location:

0.00

Packaging

Memo

0.00

Packaging

RE-PACKAGE PER PPP
USING NEW B/N
NEW LABELS REQ'D

CHG 005

105.10.22

N/A

105.10.22

105.10.22

Work Order ID 52407

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Page 3

Item ID: D350-602-011

Accept



Setup Start



Revision ID: N/A

Item Name: Heli-Utility-Pod (LH/RH)

Stop



Start Date: 9/23/09 Start Qty: 1.00



Cust Item ID:

Required Date: 9/30/09 Req'd Qty: 1.00

Customer:

Reference:

Run Start



Approvals: Process Plan: Date: Tooling: Date:

Stop



QC: Date: SPC (Y/N): Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/10/23

u 9.10.23

Picklist Print

September 23, 2009 11:44:48 AM

Page 1

Work Order ID: 52407

Parent Item: D350-602-011RevN/A

Parent Item Name: Heli-Utility-Pod (LH/RH)


Start Date: 9/23/09

Required Date: 9/30/09

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D350-602-011RevN/A		Manufactured	No				Each	2.0000	1.0000			
												
Heli-Utility-Pod (LH/RH)												

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

FG

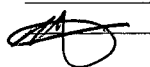
2

43695

1

47429

1

 091013

DART**RELEASED**
07.07.23

V/D 52407

DESIGN 901	DRAWN BY BC	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 13	APPROVED H	DRAWING NO. D2694	REV. H SHEET 1 OF 4
DATE 07.07.18		TITLE UTILITY POD ASSEMBLY	SCALE NTS
A	97.07.02	NEW ISSUE CREATED TO REPLACE D350-602-041 AND -043	
B	97.10.08	CHANGE RIVET PATTERN, ADD D2429	
C	98.11.12	ADD DOUBLER HOLES, REMOVE FINISH	
D	99.01.08	SEAL & HINGE CHANGE (TSR A1047 & A855/A858); INCLUDED DE09119	
E	99.12.20	CHANGE DIMENSIONS	
F	01.03.20	REDESIGN, CHANGE LATCHES & PROP	
G	01.05.08	REVERT BACK TO D2204-9 LATCH	
H	07.07.18	CHANGED RIVETS FROM AD64ABS TO AD62ABS (PAR#185)	

Qty	Part Number	Description
1	D2202-1	POD LID
1	D2202-3	POD BASE
5	D2204-9	LATCH
1	D2429-041	SPRING CLIP ASSEMBLY
1	D2462-1700	NEOPRENE SEAL
5	D2528-1	BACKER PLATE
4	D2528-3	BACKER PLATE
1	D2569	HINGE
1	D3007-041	PROP ASSEMBLY
19	AN4-5A	BOLT
1	AN4-6A	BOLT
2	AN526C632R7	SCREW
21	AN960JD416	WASHER
2	AN960JD6	WASHER
2	MS21042L06	NUT (OR MS21042-06)
20	MS21042L4	NUT (OR MS21042-4)
38	AD62ABS	RIVET

**GENERAL NOTES:**

- TRANSFER DRILL UNSPECIFIED HOLES FROM ATTACHING PART AS FOLLOWS: AN526C632 → DRILL Ø0.141
AN4 → DRILL Ø0.257
- SEAL ALL HOLES AND EDGES OF POD WITH CYANOACRYLATE GLUE
- FOR D2569 HINGE:
 - INSTALL RIVET HEADS FROM OUTSIDE OF POD
 - GRIND TRAILING EDGE OF RIVET TO PERMIT HINGE TO CLOSE
 - ENSURE ALL RIVET HOLES ARE DRILLED ON THE LARGER HINGE TABS AS SHOWN IN DETAIL A
- TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

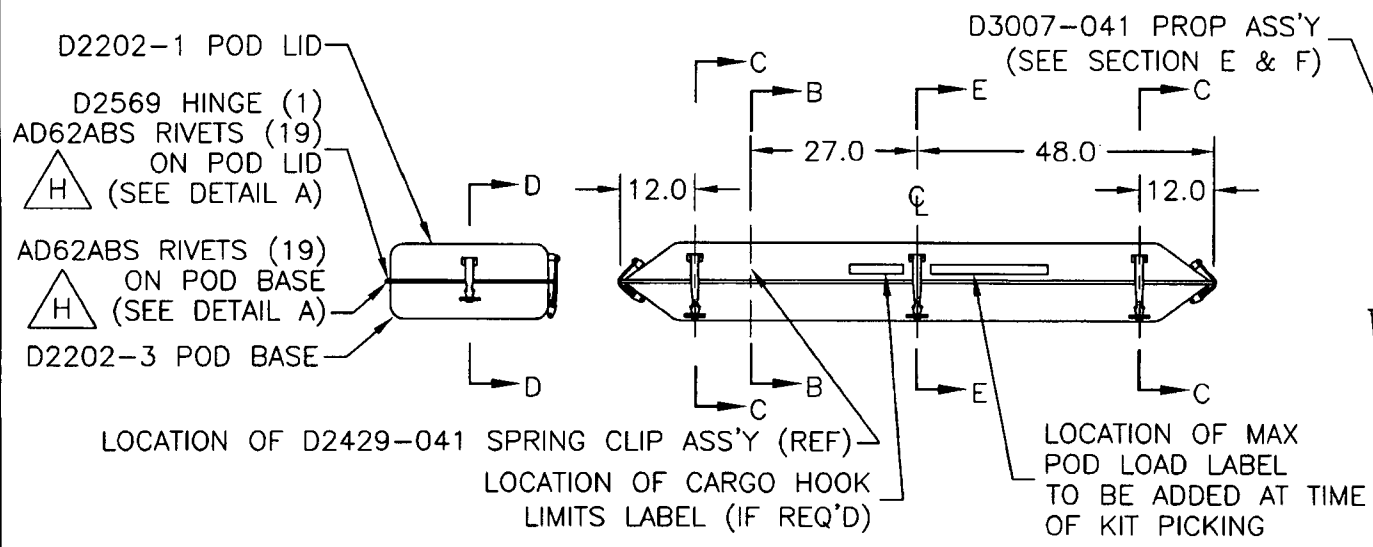
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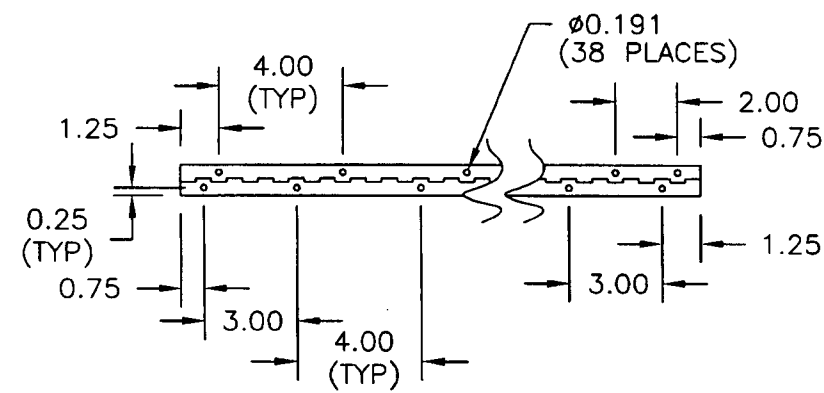
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CHECKED	13	APPROVED	13		DRAWING NO.	SHEET 2 OF 4
DATE	07.07.18	TITLE	UTILITY POD ASSEMBLY		SCALE	1:30

4058497

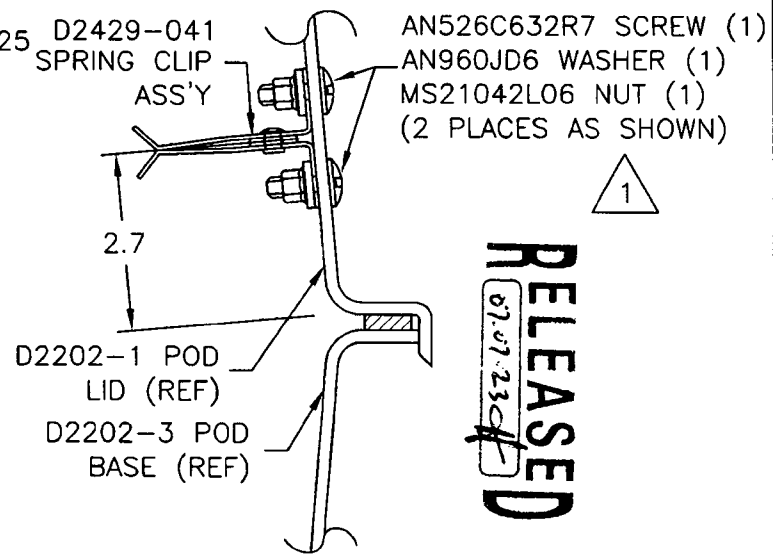


INSTALL D2462-1700 NEOPRENE SEAL ALONG TOP INSIDE EDGE OF LID (USE CONTACT CEMENT)

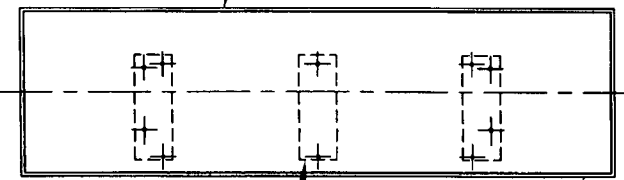
DETAIL A: HINGE
NOT TO SCALE



SECTION B-B
SCALE 2:3



D2202-3 POD BASE (REF)
VIEW LOOKING DOWN



NOTE ORIENTATION OF DOUBLERS IN POD BASE

INSTALL HINGE ON THIS EDGE

RELEASED
07.07.23

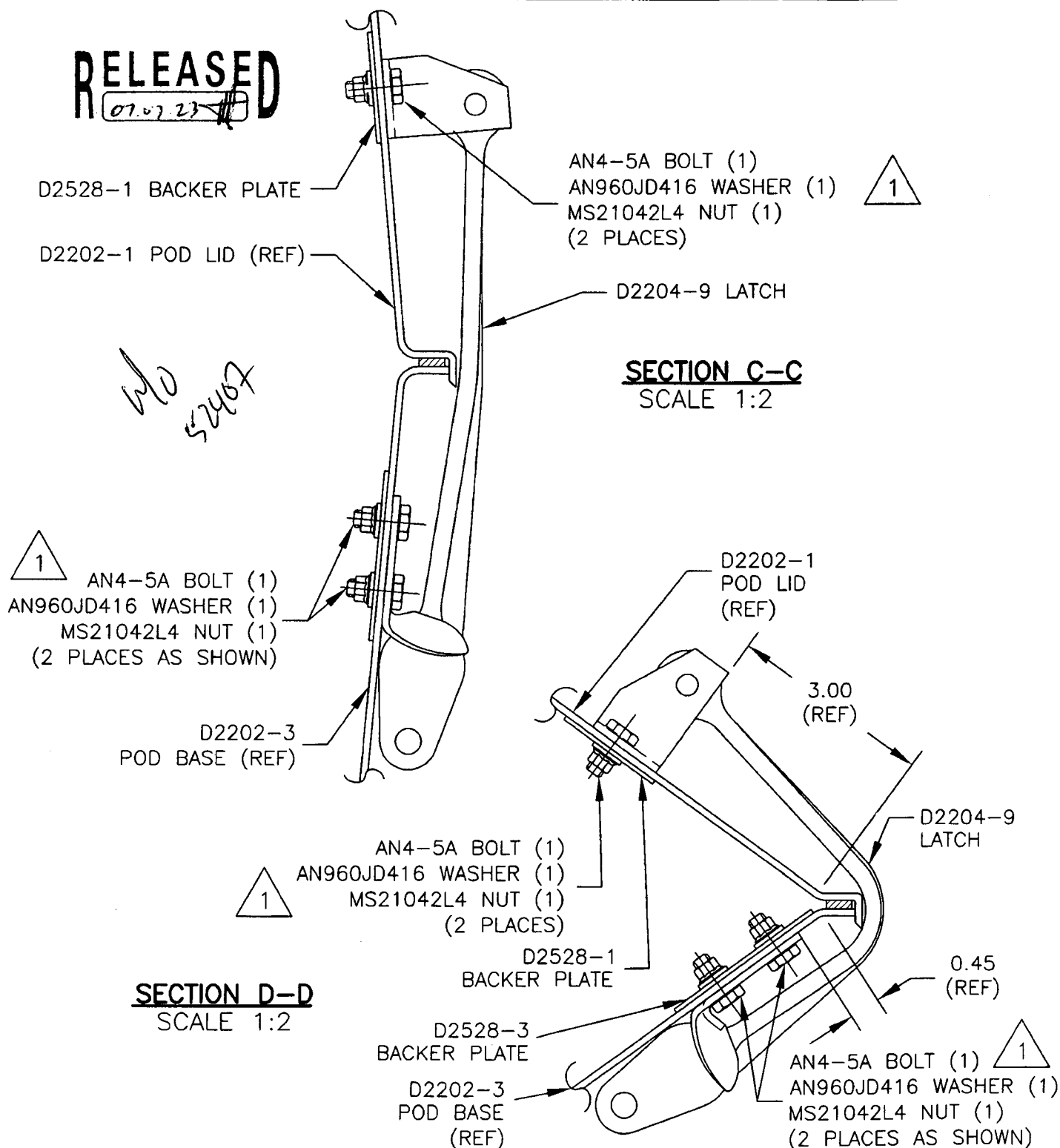
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DESIGN <i>90</i>	DRAWN BY <i>BC</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>B</i>	APPROVED <i>H</i>	DRAWING NO. D2694	REV. H SHEET 3 OF 4
DATE 07.07.18	TITLE UTILITY POD ASSEMBLY		SCALE 1:2

RELEASED
07.07.23

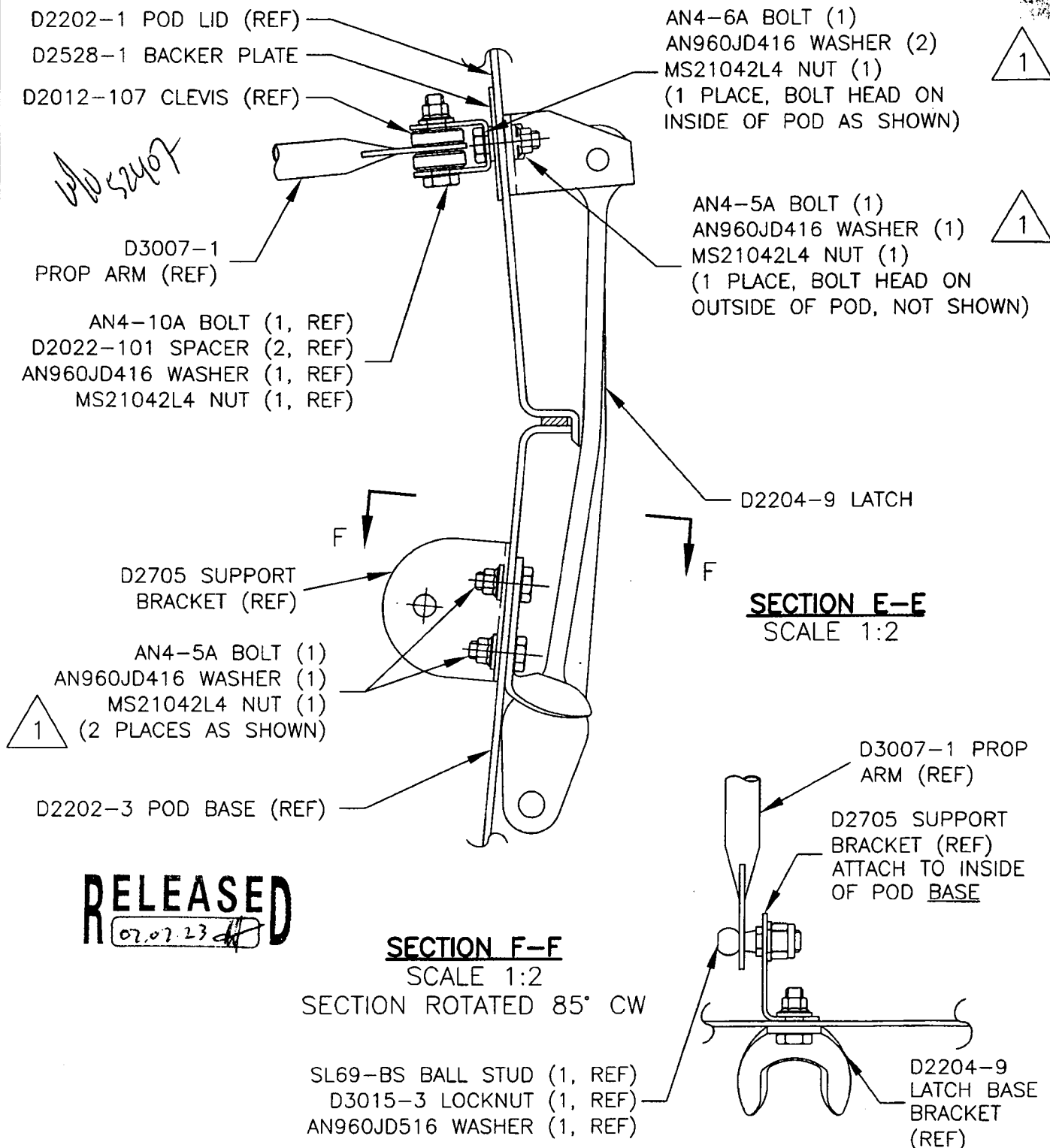


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DART

DESIGN <i>GP</i>	DRAWN BY <i>DC</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>B</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2694	REV. H SHEET 4 OF 4
DATE 07.07.18		TITLE UTILITY POD ASSEMBLY	SCALE 1:2



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Work Order ID 52710

October 8, 2009 10:40:34 AM

REFERENCE ONLY



Page 1

Item ID: D350-602-013
Revision ID: F3/A/H
Item Name: Heli-Utility-Pod, LH

Accept



Setup Start



Stop



Start Date: 10/12/09 Start Qty: 1.00
Required Date: 10/12/09 Req'd Qty: 1.00
Reference: 15



Cust Item ID:
Customer:

Approvals: Process Plan: *U*
QC:

Date:
Date:

Tooling:
SPC (Y/N):

Date:
Date:

Run Start



Stop



Sequence ID/
Work Center ID
Draw Nbr Revision Nbr

Set Up/
Run Hours

Draw Draw Plan Accept Reject Reject Insp.
Number Rev. Code Qty Qty Number Stamp

100
DOCUMENT CONTROL
0.00
DC
Memo
Document Control Photocopy bluefile & type labels per PPP D350-602-013

CHG001

MF 09-10-22

140
Small Fab
0.00
Small Fab
Memo
Small Fab PULL FROM STOCK:
1 X D350-602-011 B 47429
-Modify as per DEO 9217

150
QC
Quality Control
QC5- Inspect part completeness to step on W/O
Memo
0.00
204-10 22 1

*new Rev. B
part*

*D 3048-1 B52263
EPOCAST SOA 1111260 16 oz
HARDENER 9816 1112760 3 oz
9 oz cloth 111166 10 sq. ft
PRIMER filler gray 77045 1112704 1 qt
Activator 77755 1112704 1 pt*

DART Dart Aerospace Ltd. 1270 ABERDEEN ST. HAWKESBURY, ON, CANADA K6A 1K7				TC APPROVAL # 09-89 TEL: 1-613-632-5200	
P/N	D350-602-011	CHG	CHG005		
DESC.	Heli-Utility-Pod	STC	SH93-97		
LOT	B47429	STC	SR01144NY		
MODEL	AS350	STC			
MADE IN CANADA				02729-1	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
		110 -802-703- 011		LCB				

NOTE: Date & initial all entries